



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

REPRINT

408

D4202-1

Job Sheet 194468



Part No: D4202-1

Job Qty: 400 pcs

Part Name: Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/3/19

Job Tracking No:

Due Date: 5/31/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 10-12-07 JLM VERIFIED:DD IPP REV:B AS PER REV B 11-04-05 JLM
VERIFIED BY:DD IPP Rev:C 11.12.19 PER DWG REV.C DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	400 pcs		5/31/19	0.00	17.02	Hardinge - 1		
120	QC 8	400 pcs		5/31/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		19-05-29
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
130	Outsource - 1 - Heat Treat	400 pcs		5/31/19			MEI001-VC	9	19-05-31
140	Packaging 2-1 - Receive - B4B	400 pcs		5/31/19	0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		

				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	DP JUN 14 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
150	QC 6	400	5/31/19	0.00	0.00
		pcs			
				QC 6 - 9	
				QC 6 - 68	DAS
				QC 6 - 61	61
				QC 6 - 40	9-89

160	Handfinish - 4-1-Assembly-B4B	400 pcs	5/31/19	0.00	2.00	Handfinish - 4 - 1 - B4B	
						Handfinish - 4 - 10 - B4B	
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	00
						Handfinish - 4 - 5 - B4B	
						Handfinish - 4 - 6 - B4B	
						Handfinish - 4 - 7 - B4B	
						Handfinish - 4 - 8 - B4B	
						Handfinish - 4 - 9 - B4B	
190	Packaging 3-1 - Stock - B4B	400 pcs	5/31/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 -	

				B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	DO
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
200 QC 21 - SA	400 pcs	5/31/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	JUN 28 2019
				QC 21 - SA - 53	

DAS
70
9-89

Part Op 100 - (Hardinge) 1- Machine as per Folio FB015 ***DO NOT CHAMFER OUTSIDE DIA***
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - ***HEAT TREAT AS PER DWG D4202*** Mat'l: 6061-T6 Aluminum Tubing Per WWT-700/6
 140 - (Receive & Inspect for Damage & Mat'l Certs)
 150 - (QC6- All purchased or subcontracted products)
 160 - (Assemble as per dwg) WASH SPACER AS PER QSI005
 190 - (Identify as per dwg & Stock Location: _____) ***STOCK IN SKIDTUBE CELL***
 200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T0.500W.058	6061-T6 Round Tube .500 X.058W	140 ft (.35 ea)	100-Hardinge - 1	154912

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M6061T6T0.500W.058	140	504	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.500inches ± 0.010	0.510 0.490	Product	
2	Spacer	0.058inches ± 0.010	0.068 0.048	Product	
3	Spacer	4.145inches + 0.030 - 0.010	4.175 4.135	Product	

8x12'
2x12'
2x12'
+6'



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043598



Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

Attention: Bejenaru, Livia

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043598
PO Date: 5/31/19
Due Date: 6/21/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
kguerin@dartaero.com

Via: Ground
Pynt Terms: Net 30

Freight Terms:
Special Comments:

E-MAILED
2019-06-04

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	190332	RBE105-14181W4-15	Base 1-Issue P/O; RC 45-50 2-Bead blast 3-Material type; O1 4- Certificate of Conformity is required	Firmed	-	6/21/19	6 pcs	0 pcs	6 pcs	\$51.6666/pcs	\$310.00
2	188822	C10-5	Load Beam (Outsource process - Heat Treat) 1-Issue P/O P/O RC 53-56 2. Bead blast 3. Material 4140/4142 4. Certificate of Conformity is required	Firmed	-	6/21/19	2 pcs	0 pcs	2 pcs	\$155.00/pcs	\$310.00
3	194468	D4202-1	Spacer : Various STC's ***HEAT TREAT AS PER DWG D4202*** Mat'l: 6061-T6 Aluminum Tubing Per WWT-700/6	Firmed	-	6/21/19	408 pcs	0 pcs	408 pcs	\$1.7107/pcs	\$697.97
Grand Total:											\$1,317.97



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043598



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 6/4/19 11:16 AM Dart.Guerin.Kimberley

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
337006	1	137966

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
hb043598		AL-6061	2019/6/3	client

QUANTITÉ Quantity	No. PIÈCE / Part No.	NOM DE LA PIÈCE / Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
----------------------	-------------------------	--------------------------------	---	-----------------

408 D4202-1 14,
(408) D4202-1
JOB 194468

1 BOITE DE CARTON

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BOITE DE CARTON	1	

certificat

EXPÉDIÉ PAR: Shipped by:	
-----------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 408
POIDS EXPÉDIÉ / Weight Shipped : 14,00
QUANTITÉ RESTANTE / Quantity Remaining : 0
POIDS RESTANT / Weight Remaining : 0,00

RECEIVED

JUN 14 2019

certificat

DART AEROSPACE LTD.

QUANTITÉ EXPÉDIÉE / Quantity Shipped: 408

POIDS EXPÉDIÉ / Weight Shipped : 14,00

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2019/06/14

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
337006	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
hp043598	N/A	AL-6061		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
SOL ANNEAL SINGLE AGING TO CONDITION T42				
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	
CONDUCT	36 - 44 %IACS	82	38 - 40 %IACS	
		60 KHZ		
HARDNESS	60 HREW MIN	82	62.5 - 66.5 HREW	
		DURETE MESUREE EN HR15TW	64-66	
		HR15TW	(916)	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
408	14	D4202-1 (408) D4202-1 JOB 194468 1 BOITE DE CARTON		

DAS
61
9-89

COMMENTAIRES / comments

SOLUTION ANNEAL 985F 30 MINS
AGE HARDEN AMBIANT

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

This document and any attached documents may contain confidential or proprietary information and may be subject to export control laws and regulations. If you are not the intended recipient, you are notified that any dissemination, copying of this e-mail and any attachments thereto or use of their contents by any means whatsoever is strictly prohibited. Unauthorized export or re-export is prohibited.

Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
337006	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

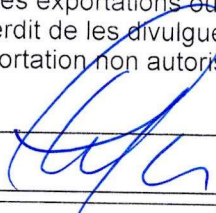
ON K6A 1K7

1

Avant que le matériel a été fabriqué, conformément, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

Ce document et les documents qui lui sont joints peuvent contenir des informations confidentielles, être soumis aux réglementations relatives au contrôle des exportations ou ayant un caractère privé. S'ils ne vous sont pas destinés, nous vous signalons qu'il est strictement interdit de les divulguer, de les reproduire ou d'en utiliser de quelque manière que ce soit le contenu. Toute exportation ou réexportation non autorisée est interdite.

APPROUVÉ par / Approved by:



DATE: 2019-06-14

Lucie Desmarais
QA Technician



METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL
order
337006

CHARGE
load
1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
hb043598	N/A	AL-6061		

SPÉCIFICATIONS DU PROCÉDÉ

processing specification

SOL ANNEAL

SINGLE AGING TO CONDITION T42

DAS

61

9-89

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
CONDUCTIVITY	38 - 44 %IACS	82	38 - 40 %IACS
HARDNESS	60 HREW MIN	82	62,5 - 66,5 HREW
			DURETE MESUREE EN HR15TW 64-66 HR15TW (916)

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
408	14	D4202-1 (408) D4202-1 JOB 194468 1 BOITE DE CARTON

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

DATE: 2019-06-14

Pierre Piché
Chief Inspector

